

# Work Order ID 52383

Tuesday, September 22, 2009 11:44:33 AM



Page 1

Item ID: D3936-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bottom

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*PL MF*

Date:

*9-22*

Tooling:

Date:

Run Start



QC:



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3936	A								
100		0.00							
									
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3936 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> ***grain direction per dwg*** 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC		0.00							
Quality Control	Memo								

B 9-10-14

B 9-10-4

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Item ID: D3936-3

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Setup Start

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Stop

Item Name: Bottom

Start Date: 9/23/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 8021014

0.00

(24)

/

QC

Memo

Quality Control

130

0.00

SB 09/10/19

0.00

4

/

Brake NC

Memo

Brake NC

Bend as per Dwg

140

QC5- Inspect part completeness to step on W/O

0.00

2) 8091015

0.00

(24)

/

QC

Memo

Quality Control

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Item ID: D3936-3	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: Bottom					
Start Date: 9/23/2009	Start Qty: 4.00		Cust Item ID:		
Required Date: 10/9/2009	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 <i>PR 09-10-20</i> 0.00				<i>(H)</i>			
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 <i>al 09/10/20</i> 0.00				<i>(x4)</i>	<i>0</i>		
170  Packaging Packaging	Identify as per dwg & Stock Location <i>\$39f</i>  Memo	0.00  0.00				<i>9/10/21</i>	<i>(40) SLP</i>		

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Item ID: D3936-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bottom

Start Date: 9/23/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/21

MF  
09-10-21

# Picklist Print

Tuesday, September 22, 2009 11:44:32 AM

Page 1

Work Order ID: 52383



Parent Item: D3936-3RevA



Parent Item Name: Bottom



Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	114.0568	3.2884			
												139-10-14
6061-T6 .040 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

114.0568

100742

3.3

102723

7.93

105842

12

106747

12.5

107461

13.1642

109396

22.28

111224

41.3826

19380

1.5

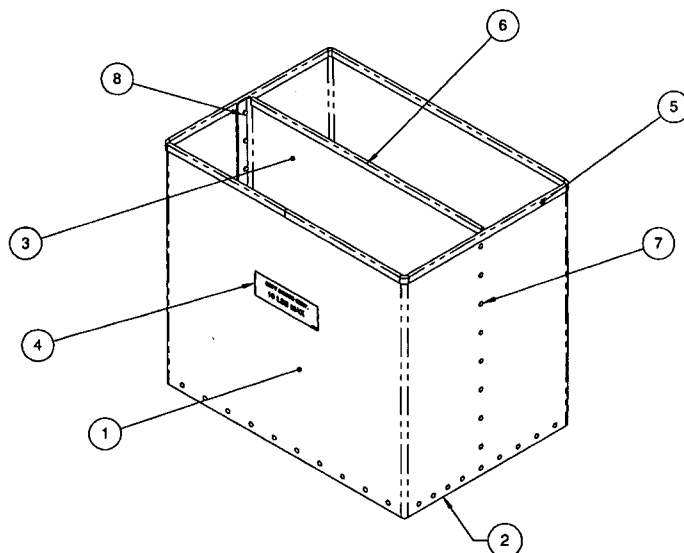
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 52383

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET



**D3936-041 MAPBOX ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

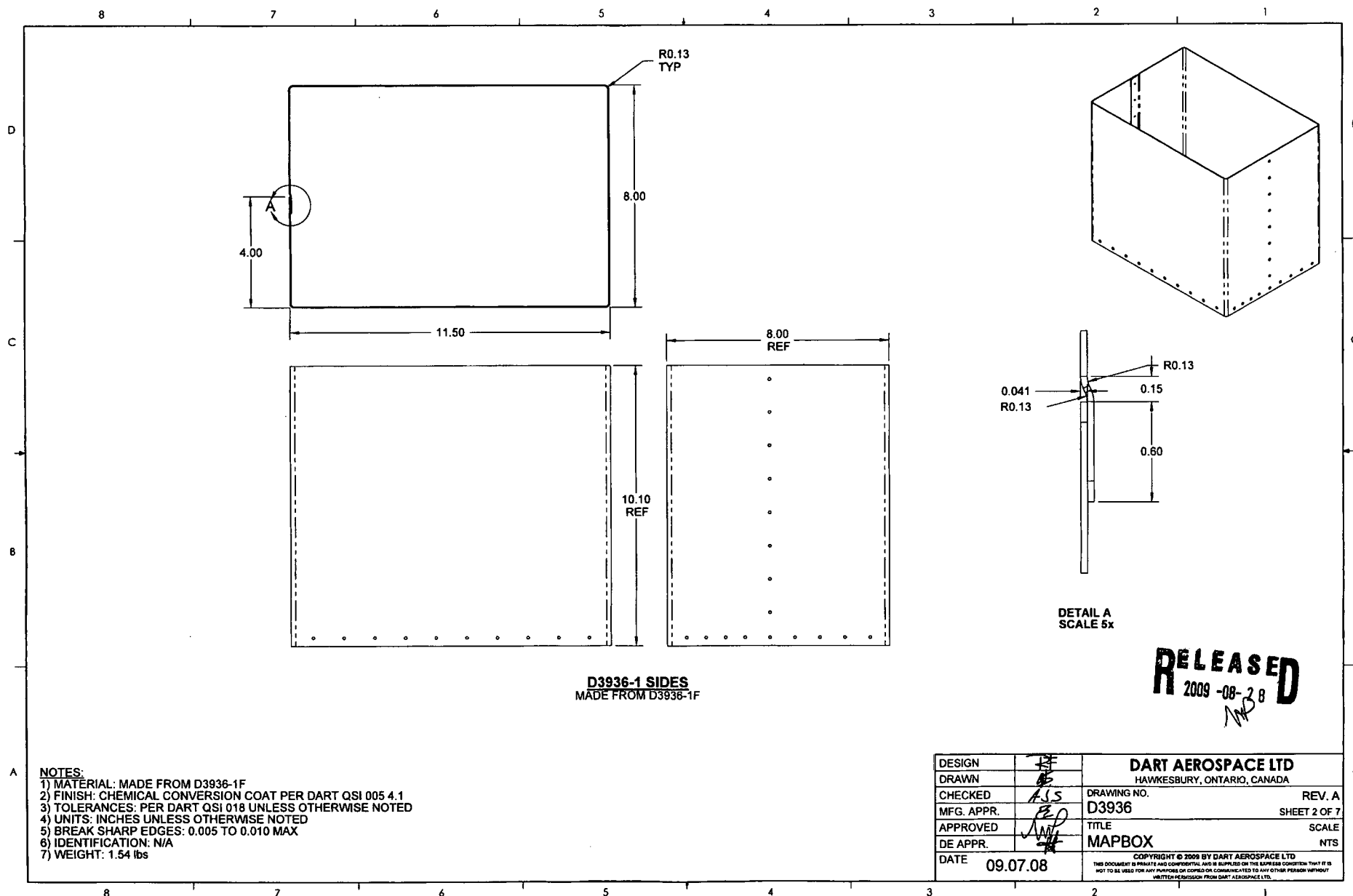
**ASSEMBLY INSTRUCTIONS**

1. BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X  $\phi 0.098$  (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X  $\phi 0.098$  HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES  $\phi 0.179 \times 100^\circ$ . DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.

**RELEASED**  
2009-08-28  
MD

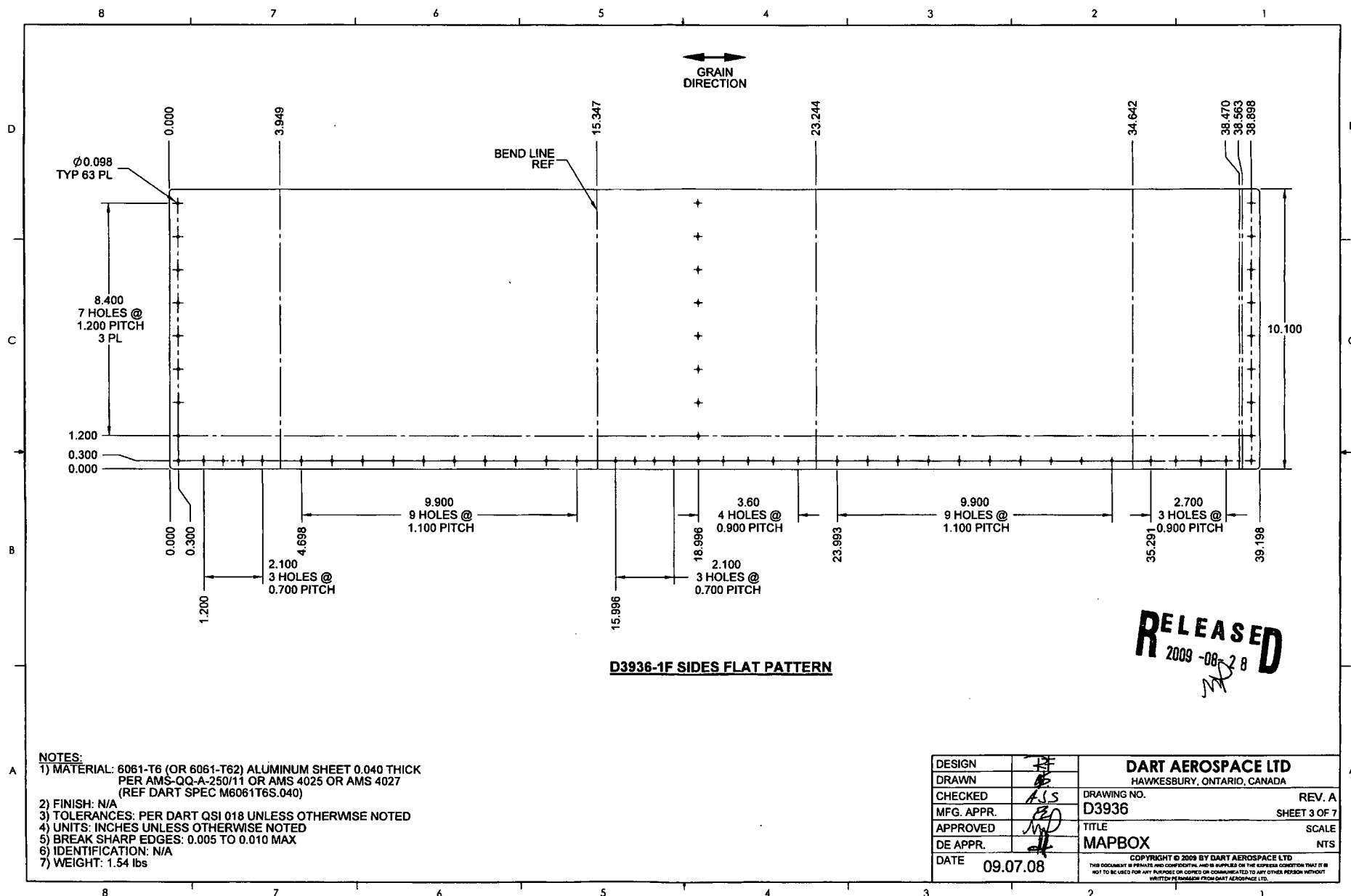
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REV.	DESCRIPTION	BY	DATE
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3936	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAPBOX	NTS
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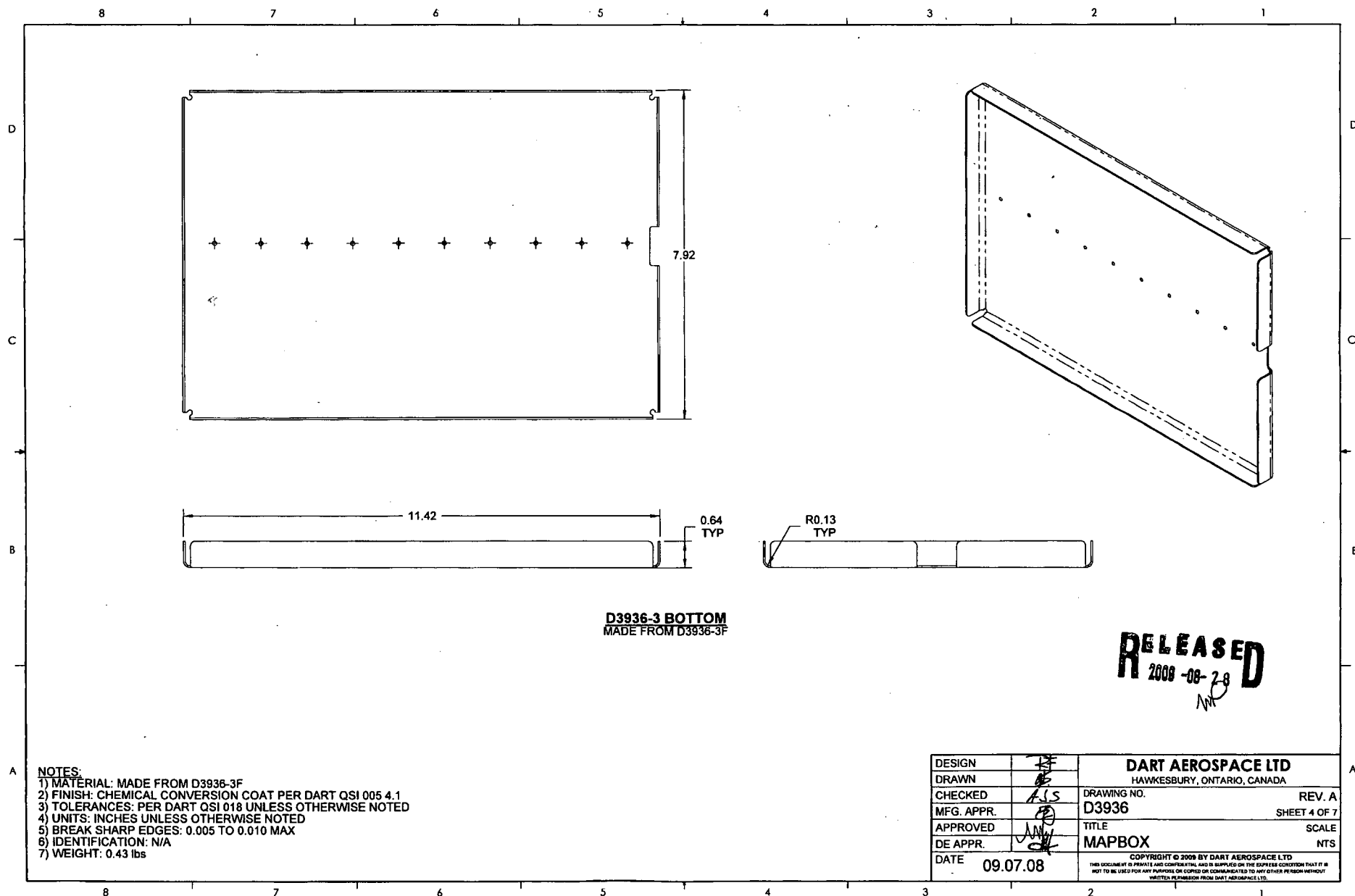




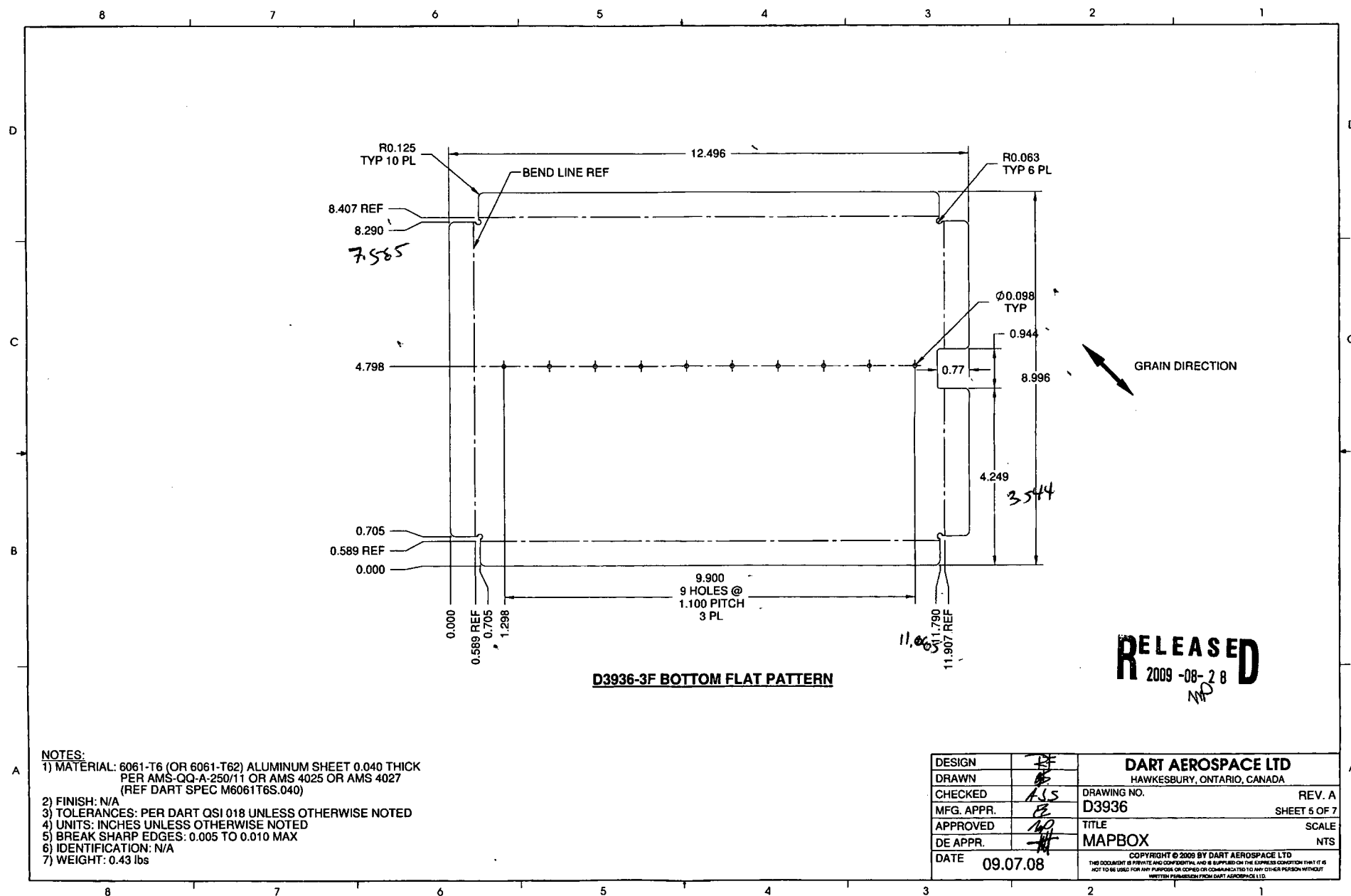
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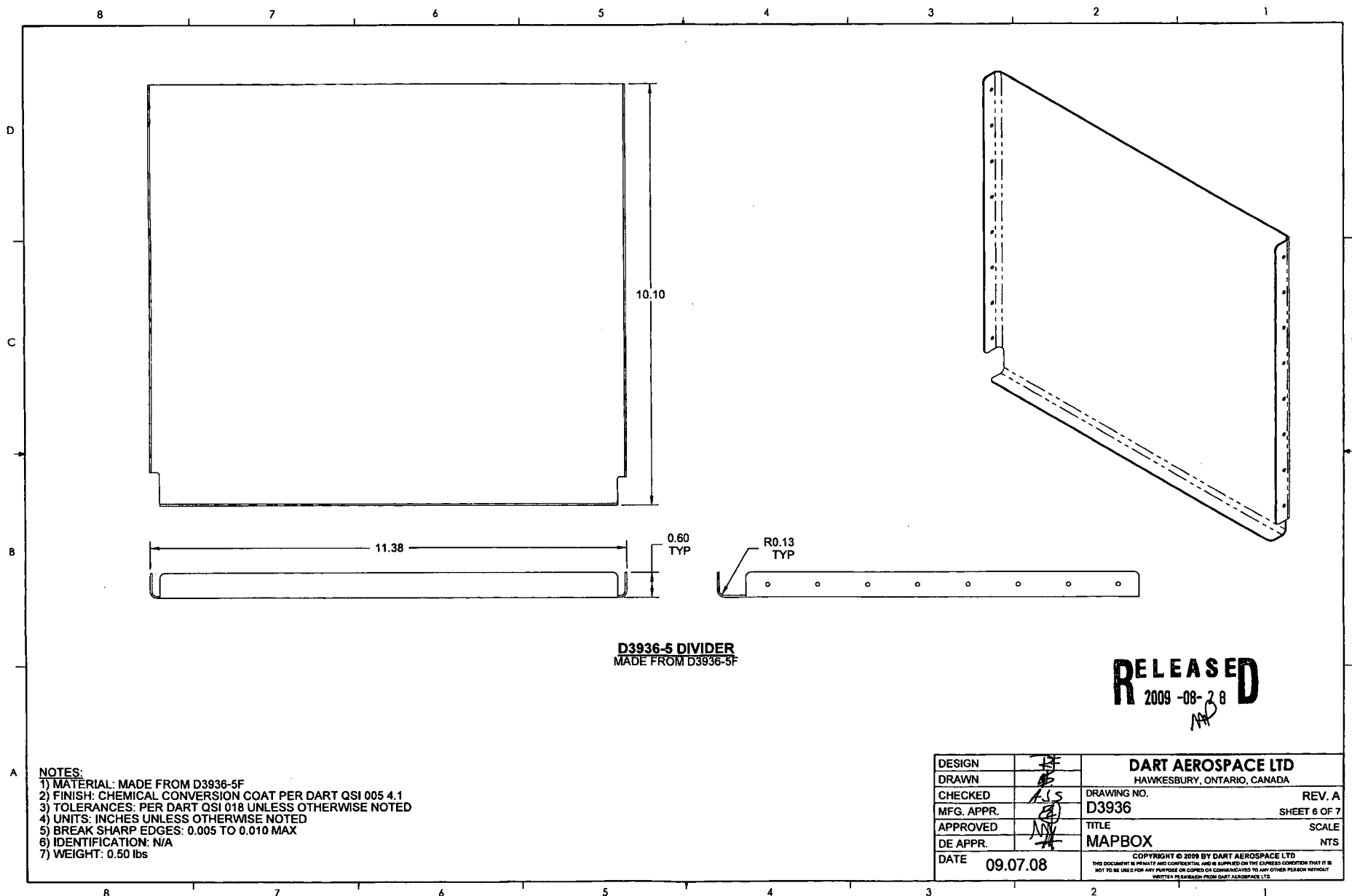
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**D3936-5 DIVIDER**  
MADE FROM D3936-5F

**RELEASED**  
2009-08-28  
MD

**NOTES:**

- 1) MATERIAL: MADE FROM D3936-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.50 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>	DRAWING NO.	REV. A
CHECKED	<i>JS</i>	<b>D3936</b>	SHEET 6 OF 7
MFG. APPR.	<i>JS</i>	TITLE	SCALE
APPROVED	<i>JS</i>	<b>MAPBOX</b>	NTS
DE APPR.	<i>JS</i>	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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